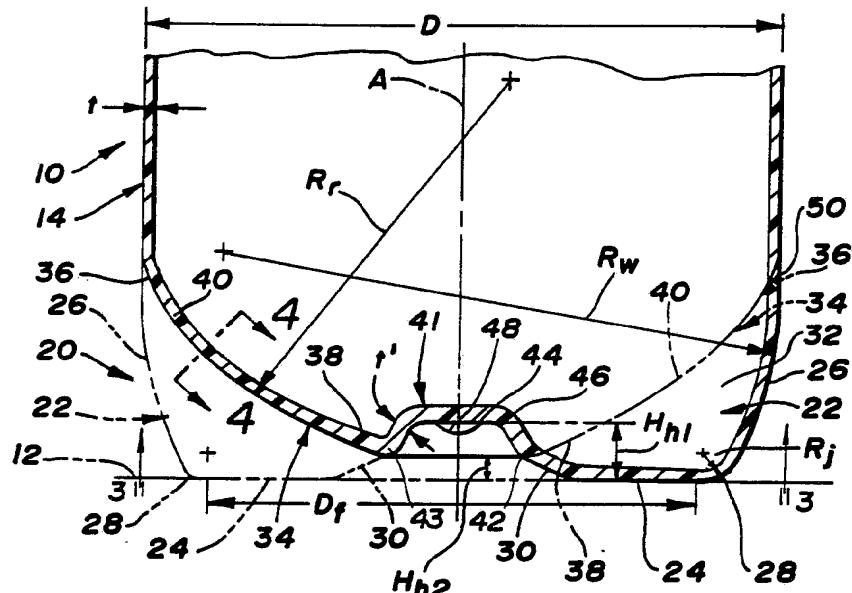




INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 5 : B65D 1/02, 1/00		A1	(11) International Publication Number: WO 92/08647 (43) International Publication Date: 29 May 1992 (29.05.92)
(21) International Application Number: PCT/US91/07387		(81) Designated States: AT, AT (European patent), AU, BB, BE (European patent), BF (OAPI patent), BG, BJ (OAPI patent), BR, CA, CF (OAPI patent), CG (OAPI patent), CH, CH (European patent), CI (OAPI patent), CM (OAPI patent), DE, DE (European patent), DK, DK (European patent), ES, ES (European patent), FI, FR (European patent), GA (OAPI patent), GB, GB (European patent), GN (OAPI patent), GR (European patent), HU, IT (European patent), JP, KP, KR, LK, LU, LU (European patent), MC, MG, ML (OAPI patent), MR (OAPI patent), MW, NL, NL (European patent), NO, RO, SD, SE, SE (European patent), SN (OAPI patent), SU ⁺ , TD (OAPI patent), TG (OAPI patent).	
(22) International Filing Date: 3 October 1991 (03.10.91)			
(30) Priority data: 614,220 15 November 1990 (15.11.90) US			
(71) Applicant: PLASTIPAK PACKAGING, INC. [US/US]; P.O. Box 2500 C, 9135 General Court, Plymouth, MI 48170 (US).			
(72) Inventors: YOUNG, William, C. ; 9565 Cherry Hill Road, Superior Township, MI 48197 (US). DARR, Richard, C. ; 3645 Good Road, Seville, OH 44273 (US).			
(74) Agent: KUSHMAN, James, A.; Brooks & Kushman, 1000 Town Center, Twenty-Second Floor, Southfield, MI 48075 (US).			

(54) Title: PLASTIC BLOW MOLDED FREESTANDING CONTAINER



(57) Abstract

A plastic container (10) comprises a freestanding base (20) with a plurality of downwardly projecting hollow legs (22), a plurality of curved ribs (34) located between the legs, and a hub (41) from which the legs and ribs provides good stability against tipping and the capability of withstanding internal pressure. Each leg (22) has a lower flat foot (24) coplanar with the other feet. Each flat foot (24) has a junction (28) with an associated outer wall (26) of the foot. A planar inner connecting portion (30) of each foot (22) is inclined and extends upwardly and inwardly to the hub (41) while sidewalls (32) of the legs are connected to the curved ribs (34) which each have a curved intermediate portion that extends between outer and inner ends (36, 38) of the rib along a curved intermediate rib portion (40).

+ DESIGNATIONS OF "SU"

Any designation of "SU" has effect in the Russian Federation. It is not yet known whether any such designation has effect in other States of the former Soviet Union.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	ES	Spain	MC	Madagascar
AU	Australia	FI	Finland	ML	Mali
BB	Barbados	FR	France	MN	Mongolia
BE	Belgium	GA	Gabon	MR	Mauritania
BF	Burkina Faso	GB	United Kingdom	MW	Malawi
BG	Bulgaria	GN	Guinea	NL	Netherlands
BJ	Benin	GR	Greece	NO	Norway
BR	Brazil	HU	Hungary	PL	Poland
CA	Canada	IT	Italy	RO	Romania
CF	Central African Republic	JP	Japan	SD	Sudan
CG	Congo	KP	Democratic People's Republic of Korea	SE	Sweden
CH	Switzerland	KR	Republic of Korea	SN	Senegal
CI	Côte d'Ivoire	LI	Liechtenstein	SU+	Soviet Union
CM	Cameroon	LK	Sri Lanka	TD	Chad
CS	Czechoslovakia	LU	Luxembourg	TC	Togo
DE	Germany	MC	Monaco	US	United States of America
DK	Denmark				

-1-

PLASTIC BLOW MOLDED FREESTANDING CONTAINER

TECHNICAL FIELD

This invention relates to a plastic blow molded container having a freestanding base structure for supporting the container while being capable of withstanding internal pressure.

BACKGROUND ART

Conventional plastic blow molded containers for holding carbonated beverages that pressurize the container for the most part in the past have been manufactured as base cup containers wherein the lower extremity of the blow molded container has a hemispherical shape that is received within an injection molded plastic base cup which supports the container during use. Such a base cup permits the hemispherical shape to be utilized to provide the requisite strength for withstanding the internal pressure while still providing a flat surface on which the container can be supported in an upright position. While such containers function satisfactorily, there is a cost involved in both manufacturing and assembling the base cup to the blow molded container and such cost must necessarily be included in the price to the consumer.

Blow molded containers capable of withstanding pressure have also been manufactured with freestanding base structures that are unitary with the container body such as disclosed by United States Patents: 3,598,270 Adomaitis; 3,727,783 Carmichael; 3,759,410 Uhlig; 3,871,541 Adomaitis; and 3,935,955 Das. These patents disclose relatively early attempts to design a freestanding blow molded container capable of withstanding internal pressure by the provision of

-2-

circumferentially spaced legs having lower feet on which the container is supported.

More recent plastic blow molded containers having freestanding base structures are disclosed by 5 German Offenlegungsschrift 29 20 122 and by United States Patents: 4,249,667 Pocock et al; 4,267,144 Collette et al; 4,276,987 Michel; 4,294,366 Chang; 4,318,489 Snyder et al; 4,335,821 Collette et al; 10 4,368,825 Motill; 4,785,949 Krishnakumar et al; 4,785,950 Miller et al; 4,850,494 Howard, Jr.; 4,850,493 Howard, Jr.; 4,867,323 Powers; and 4,910,054 Collette et al.

Certain of the containers disclosed by the above 15 patents have flat feet on which the freestanding base structure is supported. However, some of the structures involved deflect under the pressure such that it is necessary to incline the lower feet upwardly in an inward direction as disclosed by United States Patent 4,865,206 Behm et al so that the feet deflect downwardly 20 to a coplanar relationship with each other upon being subjected to the internal pressure when the container is filled.

Also, United Kingdom patent application 25 GB2189214A discloses a plastic blow molded container having a unitary base structure with a recess defined by a peripheral wall and a convex bottom wall. This recess is disclosed as functioning to centralize the preform used to blow mold the container and to also prevent the lower gate area through which the preform is injection 30 molded from becoming the lowest portion of the container in a manner that could adversely affect stability.

DISCLOSURE OF INVENTION

5 An object of the present invention is to provide an improved plastic blow molded container having a freestanding base structure that provides good stability to the container even when subjected to internal pressure.

10 In carrying out the above object, the plastic blow molded container incorporating the invention has a central axis A and includes a cylindrical body portion that extends vertically about the central axis A with a diameter D. An upper end closure of the container is unitary with the upper extremity of the cylindrical body portion and includes a dispensing spout through which the container is filled and through which the container 15 contents are subsequently dispensed as needed. A freestanding base structure of the container is unitary with the cylindrical body portion to close the lower extremity thereof and is constructed in accordance with the present invention.

20 The freestanding base structure of the invention includes a plurality of downwardly projecting hollow legs spaced circumferentially from each other with respect to the body portion. Each leg has a lower flat foot coplanar with the feet of the other legs to 25 cooperate therewith in supporting the container in an upright position. The lower flat feet have an outer diameter D_f that is at least .75 of the diameter D of the cylindrical body portion to provide good stability against tipping. Each leg also has an outer wall that 30 extends from the outer extremity of the flat foot thereof to the cylindrical body portion. The flat foot and the outer wall of each leg have an abruptly curved junction with a radius of curvature R_j less than .05 of the diameter D of the cylindrical body portion. Each

-4-

leg also has a planar inner connecting portion that is inclined and extends upwardly and inwardly from the inner extremity of its flat foot. A pair of side walls of each leg cooperate with the flat foot, the outer wall 5 and the planar inner connecting portion thereof to close the leg.

The freestanding base structure of the container also includes a plurality of curved ribs spaced circumferentially from each other between the downwardly 10 projecting legs and connecting the adjacent side walls of the legs. Each rib has an outer end that extends upwardly and is connected to the cylindrical body portion of the container. Each rib also has an inner lower end located between the inner connecting portions 15 of the legs on opposite sides of the legs and extending downwardly and inwardly toward the central axis A of the container. Each rib also has a curved intermediate portion that extends between the outer and inner ends thereof with an outwardly convex shape.

20 A generally round hub of the freestanding base structure of the container is located along the central axis A with the legs and the curved ribs of the base structure extending radially in an outward direction from the hub. This hub has a diameter D_h in the range of 25 about .15 to .25 of the diameter D of the cylindrical body portion. The hub also has connections to the upwardly extending planar inner connecting portions of the legs and the hub also has connections to the downwardly extending inner ends of the curved ribs.

30 The freestanding base structure of the plastic blow molded container as described above provides good stability against tipping which is especially useful prior to filling when the container is empty and being moved along a filling line, and the freestanding base

-5-

structure has a construction and wall thickness that is capable of withstanding internal pressure after filling.

In one preferred embodiment, the hub includes a round upper wall and an annular wall having an upper end connected to its upper wall, and the annular extends downwardly from the upper wall with an inclination of at least 45° with respect to the flat feet of the legs. The annular wall of the hub has a lower end connected to the planar inner connecting portions of the legs and also connected to the inner ends of the curved ribs. Furthermore, the upper wall of the hub is spaced above the flat feet of the legs by a height H_{h1} in the range of about .08 to .12 of the diameter D of the cylindrical body portion. In addition, the lower end of the annular wall of the hub is preferably spaced above the flat feet of the legs by a height H_{h2} in the range of about .035 to .065 of the diameter D of the cylindrical body portion. Best results are achieved when the container is constructed with the height H_{h1} about .1 of the diameter D of the cylindrical body portion, the height H_{h2} in the range of about .04 to .06 of the diameter D of the cylindrical body portion, and the annular wall of the hub having an inclination of at least 60° with respect to the flat feet of the legs.

In another preferred embodiment of the plastic blow molded container, the hub of the freestanding base structure has a generally flat shape that extends horizontally and includes a periphery connected to the upwardly extending planar inner connecting portions of the legs and to the downwardly extending inner ends of the curved ribs. This flat hub is preferably spaced above the plane of the flat feet by a height H_h that is in the range of about .035 to .065 of the diameter D of the cylindrical body portion.

-6-

In a further embodiment of the plastic blow molded container, the hub of the freestanding base structure has a downwardly extending shape including a periphery connected to the inwardly extending planar inner connecting portions of the legs and to the downwardly extending inner ends of the curved ribs. This downwardly extending hub preferably has a curved shape which most preferably has a radius of curvature that is less than one-half of the radius of curvature of the curved intermediate portion of each rib. Furthermore, the downwardly extending hub preferably has a curved lower extremity that is spaced above the plane of the flat feet by a height H_h that is in the range of about .025 to .035 of the diameter D of the cylindrical body portion.

Each embodiment of the plastic blow molded container has the cylindrical body portion provided with a nominal wall thickness t and has the inner extremities of the flat feet, the planar inner connecting portions of the legs, the inner lower ends of the curved ribs and the hub each provided with a wall thickness t' that is at least 1.7 times the nominal wall thickness t of the cylindrical body portion.

Each embodiment of the plastic blow molded container has the lower flat foot of each leg provided with a truncated wedge shape and each curved rib has a generally flat cross section between its ends. The outer wall of each leg has a curved shape including an upper end that is tangent with the adjacent portion of the lower extremity of the cylindrical body portion. This outer wall of each leg preferably has a radius of curvature R_w greater than .75 of the diameter D of the cylindrical body portion. Each rib of the preferred construction of the container has a radius of curvature R_r greater than about .6 of the diameter D of the

-7-

cylindrical body portion and has a center of curvature on the opposite side of the central axis A from the rib.

The preferred construction of each embodiment of the plastic blow molded container is disclosed as including an odd number of legs and ribs with each leg located in a diametrically opposite relationship to an associated rib. Five legs and five ribs make up the freestanding base structure of each disclosed embodiment with each leg being located diametrically opposite an associated rib and with the legs and ribs extending radially from the hub in a circumferentially alternating relationship.

The objects, features and advantages of the present invention are readily apparent from the following detailed description of the best modes for carrying out the invention when taken in connection with the accompanying drawings.

BRIEF DESCRIPTION OF DRAWINGS

FIGURE 1 is a side elevational view taken partially in section through one embodiment of a plastic blow molded container which includes a freestanding base structure constructed in accordance with the present invention;

FIGURE 2 is an enlarged view of a portion of Figure 1 and further illustrates the construction of the freestanding base structure which has a central round hub that is illustrated as having an upwardly extending construction;

FIGURE 3 is a bottom plan view of the container taken along the direction of line 3-3 in Figure 2 to

-8-

further illustrate the construction of the freestanding base structure;

5 FIGURE 4 is a sectional view taken along the direction of line 4-4 in Figure 2 to illustrate the construction of ribs that are located between legs of the freestanding base structure;

10 FIGURE 5 is a sectional view similar to Figure 2 but illustrating another embodiment of the blow molded container wherein the central round hub of the freestanding base structure has a generally flat shape that extends horizontally;

FIGURE 6 is a bottom plan view of the container taken along the direction of line 6-6 in Figure 5;

15 FIGURE 7 is a sectional view taken in the same direction as Figures 2 and 5 but illustrating a further embodiment wherein the central round hub of the freestanding base structure has a downwardly extending construction; and

20 FIGURE 8 is a bottom plan view taken along the direction of line 8-8 of Figure 7.

BEST MODES FOR CARRYING OUT THE INVENTION

With reference to Figure 1 of the drawings, a plastic blow molded container constructed in accordance with the present invention is generally indicated by 10 and has a central axis A that extends vertically with the container supported on a horizontal surface 12 as shown. The plastic blow molded container 10 includes a cylindrical body portion 14 that extends vertically about the central axis A with a diameter D. An upper end closure 16 of the container is unitary with the

-9-

upper extremity of the cylindrical body portion 14 and includes a dispensing spout which is illustrated as having a thread 18 for securing an unshown cap-type closure. The container also includes a freestanding base structure 20 constructed according to the present invention and unitary with the cylindrical body portion 14 to close its lower extremity. This freestanding base structure 20 as is more fully hereinafter described has the capability to provide good stability against tipping, which is especially desirable when the container is empty and being conveyed upright after manufacturing thereof and during movement through a filling line, and the freestanding base structure is also capable of withstanding internal pressure such as when the container is filled with carbonated beverage.

With combined reference to Figures 1 through 3, the freestanding base structure 20 includes a plurality of downwardly projecting hollow legs 22 spaced circumferentially from each other with respect to the body portion. Each leg 22 has a lower flat foot 24 coplanar with the feet of the other legs to cooperate therewith in supporting the container in an upright position such as shown in Figure 1. The lower flat feet 24 have an outer diameter D_h that is at least .75 of the diameter D of the cylindrical body portion to provide good stability of the container against tipping. Each leg 22 also has an outer wall 26 that extends from the outer extremity of the flat foot 24 thereof to the cylindrical body portion 14. The flat foot 24 and the outer wall 26 of each leg 22 have an abruptly curved junction 28 best shown in Figure 2. This junction 28 has a radius of curvature R_j at the outer surface of the container less than .05 of the diameter D of the cylindrical body portion. Each leg 22 also has a planar inner connecting portion 30 that is inclined and extends upwardly and inwardly from the inner extremity of its

-10-

flat foot 24. As best shown in Figures 2 and 3, each leg 22 also has a pair of side walls 32 that cooperate with the lower foot 24, the outer wall 26 and the inner planar connecting portion 30 to close the leg.

5 As best illustrated in Figures 2 through 4, the freestanding base structure 20 also includes a plurality of curved ribs 34 spaced circumferentially from each other between the downwardly projecting legs 22 and connecting the adjacent side walls 32 of the legs. Each
10 rib 34 as shown best in Figure 2 has an outer upper end 36 that extends upwardly and is connected to the cylindrical body portion 14 of the container. Each rib 34 also has an inner lower end 38 located between the inner connecting portions 30 of the legs 22 on opposite
15 sides thereof as shown in Figure 3 and extending downwardly and inwardly toward the central axis A of the container. As best shown in Figure 2, each rib 34 also has a curved intermediate portion 40 that extends between the outer and inner ends 36 and 38 thereof with
20 an outwardly convex shape.

As best illustrated in Figures 2 and 3, the freestanding base structure 20 of the container also includes a generally round hub 41 located along the central axis A with the legs 22 and curved ribs 34 extending radially therefrom in a circumferentially alternating relationship to each other. This hub 41 has a diameter D_h in the range of about .15 to .25 of the diameter D of the cylindrical body portion. Hub 41 also includes connections 42 to the upwardly extending planar inner connecting portions 30 of the legs, and the hub also has connections 43 to the downwardly extending inner ends 38 of the curved ribs.

In the embodiment of the container shown in Figures 2 and 3, the hub 41 of the freestanding base

-11-

structure has an upwardly extending shape whose periphery is connected to the upwardly extending planar inner connecting portions 30 of the legs and to the downwardly extending inner ends 38 of the curved ribs as described above. This upwardly extending hub 41 includes a round upper wall 44 and an annular wall 46 having an upper end connected to the upper wall thereof and extending downwardly therefrom with an inclination of at least 45° with respect to the flat feet 24 of the legs 22. Annular wall 46 of the hub 41 also has a lower end connected to the inner connecting portions 30 of the feet 22 and to the inner ends 38 of the curved ribs 34. The upper wall 44 of the hub 41 is spaced above the plane of the flat feet 24 of the legs 22 by a height H_{h1} in the range of about .08 to .12 of the diameter D of the cylindrical body portion. These sizes of the diameter D_h and the height H_{h1} of the freestanding base construction described above are important to ensure that the preform from which the container is made can be expanded to define the junctions 28 between the outer extremities of the feet 24 and the outer walls 26 with a sufficiently thick wall thickness so as to have the requisite strength. Furthermore, the lower end of the annular wall 46 of the hub 41 is spaced above the plane of the flat feet 24 by a height H_{h2} in the range of about .035 to .065 of the diameter D of the cylindrical body portion. This size of the height H_{h2} maintains the center of the container spaced upwardly from the surface 12 sufficiently so that the sprue nub 48, which is used in the injection molding of the preform utilized to blow mold the container, is spaced sufficiently above the support surface 12 so that the feet 24 are maintained in their coplanar relationship in surface-to-surface engagement with the support surface. Best results are achieved when the height H_{h1} is about .1 of the diameter D of the cylindrical body portion, the height H_{h2} is in the range of about .04 to .06 of the diameter D of the

-12-

5 cylindrical body portion and the annular wall 46 of the hub has an inclination of at least 60° with respect to the flat feet 24 of the legs. As disclosed, the annular wall 46 of the hub has an inclination of about 76° with respect to the flat feet 24 of the legs.

10 With reference to Figures 5 and 6, another embodiment of the container 10' has much of the same construction as the previously described embodiment except as will be noted and thus has like reference numerals identifying like components thereof such that the previous description is applicable and need not be repeated. However the hub 41' of the freestanding base structure 20' of this embodiment has a generally flat shape that extends horizontally as opposed to an upwardly extending shape as with the previously described embodiment. This horizontally extending flat hub 41' has a periphery connected by the connections 42 to the upwardly extending planar inner connecting portions 30 of the legs and by the connections 43 to the downwardly extending inner ends 38 of the curved ribs.

15 The flat hub 41' is spaced above the plane of the lower feet 24 by a height H_h that is in the range of about .035 to .065 of the diameter D of the cylindrical body portion so as to thus be located above the support surface 12 sufficiently far so that the injection molding sprue nub 48' does not adversely affect stability of the container. Otherwise, this embodiment of the container 10' shown in Figures 5 and 6 is the same as the previously described embodiment of Figures 1 through 4.

20

25

30

35 With reference to Figures 7 and 8, a further embodiment of the container 10'' also has generally the same construction as the embodiment of Figures 1 through 4 except as will be noted such that like reference numerals are applied to like components thereof and much

-13-

of the previous description is applicable and thus will not be repeated. The plastic blow molder container 10'' illustrated in Figure 7 and 8 has its generally round hub 41'' located along the central axis A provided with a downwardly extending shape whose periphery is connected by the connections 42 to the upwardly extending planar inner connecting portions 30 of the legs and by the connections 43 to the downwardly extending inner ends 38 of the curved ribs. More specifically as best illustrated in Figure 7, the central hub 41'' preferably has a curved shape and most preferably has a radius of curvature R_h that is less than one-half the radius of curvature R_r of the curved intermediate portion 40 of each rib 34. Furthermore, the downwardly extending hub 41'' has a curved lower extremity spaced above the plane of the flat feet 24 by a height H_h that is in the range of about .025 to .035 of the diameter D of the cylindrical body portion such that the injection molding sprue nub 48'' is spaced above the support surface 12 so as not to adversely affect stability of the container. In the specific construction disclosed, the radius of curvature R_r of the downwardly extending hub 41'' is about one-third the radius of curvature R_r of the intermediate portion 40 of the rib 34 which, as is hereinafter described, is greater than about .6 of the diameter D of the cylindrical body portion 14.

In each of the embodiments described above as illustrated in Figures 2, 5 and 7, the cylindrical body portion 14 of the container 10, 10' and 10'' has a nominal wall thickness t which is normally in the range of about .009 to .011 of an inch. The construction of the freestanding base structure 20 has the inner extremities of the flat feet 24, the inner connecting portions 30 of the legs, the inner lower ends 38 of the curved ribs 34 and the associated hub 41, 41' and 41''

-14-

each provided with a wall thickness t' that is at least 1.7 times the nominal wall thickness t of the cylindrical body portion and preferably about 2 times the nominal wall thickness t .

5 With reference to Figures 3, 6 and 8, each container embodiment has its freestanding base structure constructed such that the lower flat foot 24 of each leg 22 has a truncated wedge shape whose truncated inner end terminates at the associated planar inner connecting portion 30 of the foot and whose curved outer end is 10 defined at the junction 28 with the associated outer wall 26.

15 As illustrated in Figure 4, each rib 34 between the adjacent pair of leg side walls 32 has its curved shape provided with a flat cross section along the intermediate rib portion 40 between its ends. This flat cross section of each rib 34 thus extends from its outer upper end 36 along the intermediate rib portion 40 to its inner lower end 38 at the junction with the lower 20 end of the annular wall 46 of the hub 42. The flat rib cross-section shown in Figure 4 is illustrative of the construction of each container embodiment 10, 10' and 10''.

25 As illustrated in Figures 2, 5 and 7, the outer wall 26 of each leg 22 has a curved shape including an upper end 50 that is tangent with the adjacent portion of the lower extremity of the cylindrical body portion 14 of the container. The curvature of this outer wall 26 as well as the curvature of each rib 34 constitute 30 features that enable the freestanding base structure to have good stability as well as the strength to withstand internal pressure as part of the construction previously described. More specifically, the outer wall 26 of each foot has a radius of curvature R_w greater than .75 of the

-15-

5 diameter D of the cylindrical body portion so that the outer diameter D_f of the flat feet 24 can be as large as possible when the junction 28 is constructed as described previously with a radius of curvature R_j of less than .05 of the diameter D of the cylindrical body portion. Furthermore, each rib 34 has a radius of curvature R_r greater than about .6 of the diameter D of the cylindrical body portion and with a center of curvature on the opposite side of the central axis A from the rib.

10

15 As shown in Figures 3, 6 and 8, the freestanding base 20 of the container 10 is disclosed as including an odd number of legs 22 and ribs 24 with each leg 22 located in a diametrically opposite relationship to the associated rib about the central axis A. More specifically, the containers 10, 10' and 10'' are each illustrated as including five legs 22 and five ribs 34 which is the preferred number so as to provide best stability against tipping such as when supported on

20 refrigerator wire shelves or other discontinuous supports.

25 The blow molded containers 10, 10' and 10'' shown are manufactured from polyethylene terephthalate by injection stretch blow molding. This produces a biaxially oriented container wall with increased strength and the capability of withstanding internal pressure when made with the freestanding base structure as described above.

30 While the best modes for practicing the invention has been described in detail, those familiar with the art to which this invention relates will recognize various alternative designs and embodiments for practicing the invention as defined by the following claims.

WHAT IS CLAIMED IS:

1. In a plastic blow molded container having a central axis A and including a cylindrical body portion that extends vertically about the central axis A with a diameter D, an upper end closure unitary with the upper extremity of the cylindrical body portion and including a dispensing spout, and a freestanding base structure unitary with the cylindrical body portion to close the lower extremity thereof, said freestanding base structure comprising:

10 a plurality of downwardly projecting hollow legs spaced circumferentially from each other with respect to the body portion; each leg having a lower flat foot coplanar with the feet of the other legs to cooperate therewith in supporting the container in an upright position; the lower flat feet having an outer diameter D_f that is at least .75 of the diameter D of the cylindrical body portion to provide good stability against tipping; each leg also having an outer wall that extends from the outer extremity of the flat foot thereof to the cylindrical body portion; the flat foot and the outer wall of each leg having an abruptly curved junction with a radius of curvature R_j less than .05 of the diameter D of the cylindrical body portion; each leg 15 also having a planar inner connecting portion that is inclined and extends upwardly and inwardly from the inner extremity of the flat foot thereof; and each leg 20 also having a pair of side walls that cooperate with the flat foot, the outer wall and the inner planar connecting portion to close the leg;

25 a plurality of curved ribs spaced circumferentially from each other between the downwardly projecting legs and connecting the adjacent side walls of the legs; each rib having an outer upper end that 30 extends upwardly and is connected to the cylindrical body portion of the container; each rib also having an 35

-17-

5 inner lower end located between the inner connecting portions of the legs on opposite sides thereof and extending downwardly and inwardly toward the central axis A of the container; and each rib also having a curved intermediate portion that extends between the outer and inner ends thereof with an outwardly convex shape; and

10 a generally round hub that is located along the central axis A with the legs and curved ribs extending radially therefrom; said hub having a diameter D_h in the range of about .15 to .25 of the diameter D of the cylindrical body portion; and the hub having connections to the upwardly extending planar inner connecting portions of the legs and the hub also having connections to the downwardly extending inner ends of the curved ribs.

20 2. A plastic blow molded container as in claim 1 wherein the hub of the base structure has an upwardly extending shape including a periphery connected to the upwardly extending planar inner connecting portions of the legs and to the downwardly extending inner ends of the curved ribs.

25 3. A plastic blow molded container as in claim 2 wherein the upwardly extending hub includes a round upper wall and an annular wall having an upper end connected to the upper wall thereof and extending downwardly therefrom with an inclination of at least 45° with respect to the flat feet of the legs, and the upper wall of the hub being spaced above the plane of the flat feet of the legs by a height H_{h1} in the range of about .08 to .12 of the diameter D of the cylindrical body portion.

30 4. A plastic blow molded container as in claim 3 wherein the lower end of the annular wall of the hub

-18-

is spaced above the plane of the flat feet of the legs by a height H_{h1} in the range of about .035 to .065 of the diameter D of the cylindrical body portion.

5 5. A plastic blow molded container as in claim 4 wherein the height H_{h1} is about .1 of the diameter D of the cylindrical body portion, the height H_{h2} is in the range of about .04 to .06 of the diameter D of the cylindrical body portion and wherein the annular wall of the hub has an inclination of at least 60° with respect 10 to the flat feet of the legs.

15 6. A plastic blow molded container as in claim 1 wherein the hub has a generally flat shape that extends horizontally and has a periphery connected to the upwardly extending planar inner connecting portions of the legs and to the downwardly extending inner ends 15 of the curved ribs.

20 7. A plastic blow molded container as in claim 6 wherein the flat hub is spaced above the plane of the flat feet by a height H_h that is in the range of about .035 to .065 of the diameter D of the cylindrical body portion.

25 8. A plastic blow molded container as in claim 1 wherein the hub has a downwardly extending shape including a periphery connected to the upwardly extending planar inner connecting portions of the legs and to the downwardly extending inner ends of the curved ribs.

30 9. A plastic blow molded container as in claim 8 wherein the downwardly extending hub has a curved shape.

-19-

10. A plastic blow molded container as in claim 9 wherein the curved shape of the downwardly extending hub has a radius of curvature that is less than one-half the radius of curvature of the curved intermediate portion of each rib, and the downwardly extending hub having a curved lower extremity that is spaced above the plane of the flat feet of the legs by a height H_h that is in the range of about .025 to .035 of the diameter D of the cylindrical body portion.
- 10 11. A plastic blow molded container as in claim 1 wherein the cylindrical body portion has a nominal wall thickness t and wherein the planar inner extremities of the flat feet, the inner connecting portions of the legs, the inner lower ends of the curved ribs, and the hub each has a wall thickness t' that is at least 1.7 times the nominal wall thickness t of the cylindrical body portion.
- 15 12. A plastic blow molded container as in claim 1 wherein the lower flat foot of each leg has a truncated wedge shape.
- 20 13. A plastic blow molded container as in claim 1 or 12 wherein each curved rib has a generally flat cross section between its ends.
- 25 14. A plastic blow molded container as in claim 1 wherein the outer wall of each leg has a curved shape including an upper end that is tangent with the adjacent portion of the lower extremity of the cylindrical body portion.
- 30 15. A plastic blow molded container as in claim 14 wherein the outer wall of each leg has a radius of curvature R_w greater than .75 of the diameter D of the cylindrical body portion.

-20-

16. A plastic blow molded container as in claim 1, 14 or 15 wherein each rib has a radius of curvature R_r greater than about .6 of the diameter D of the cylindrical body portion and with a center of curvature 5 on the opposite side of the central axis A from the rib.

17. A plastic blow molded container as in claim 1, 14 or 15 which includes an odd number of legs and ribs with each leg located in a diametrical opposite relationship to an associated rib.

10 18. A plastic blow molded container as in claim 17 which includes five legs and five ribs.

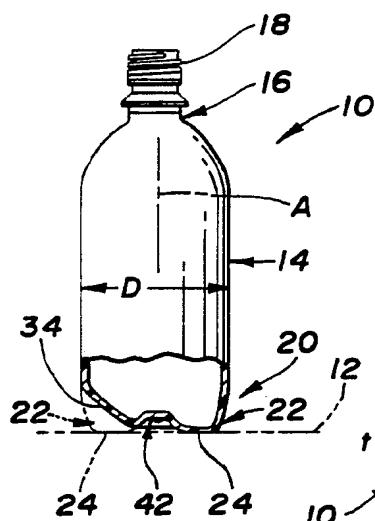


Fig. 1

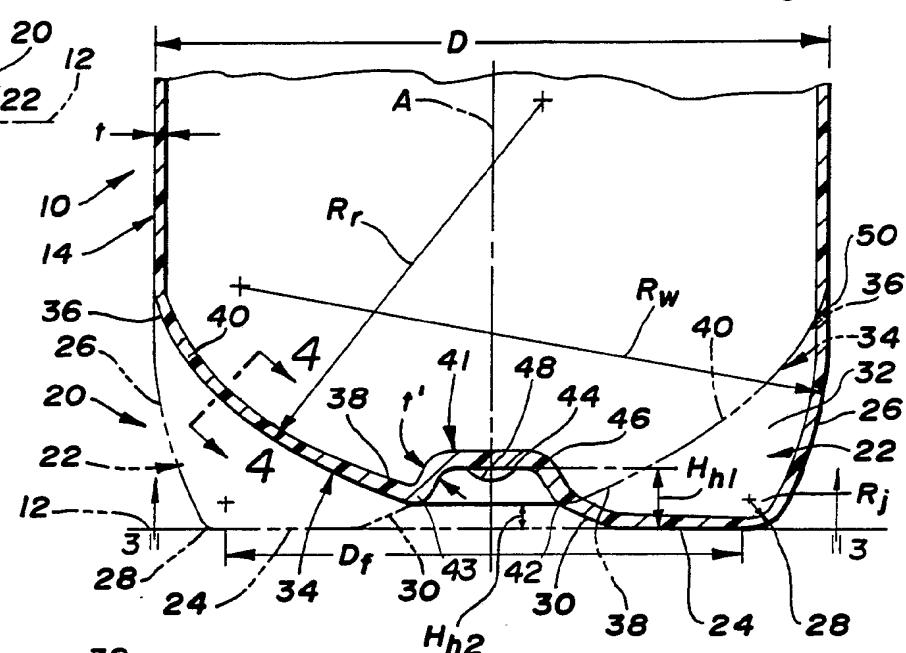


Fig. 2

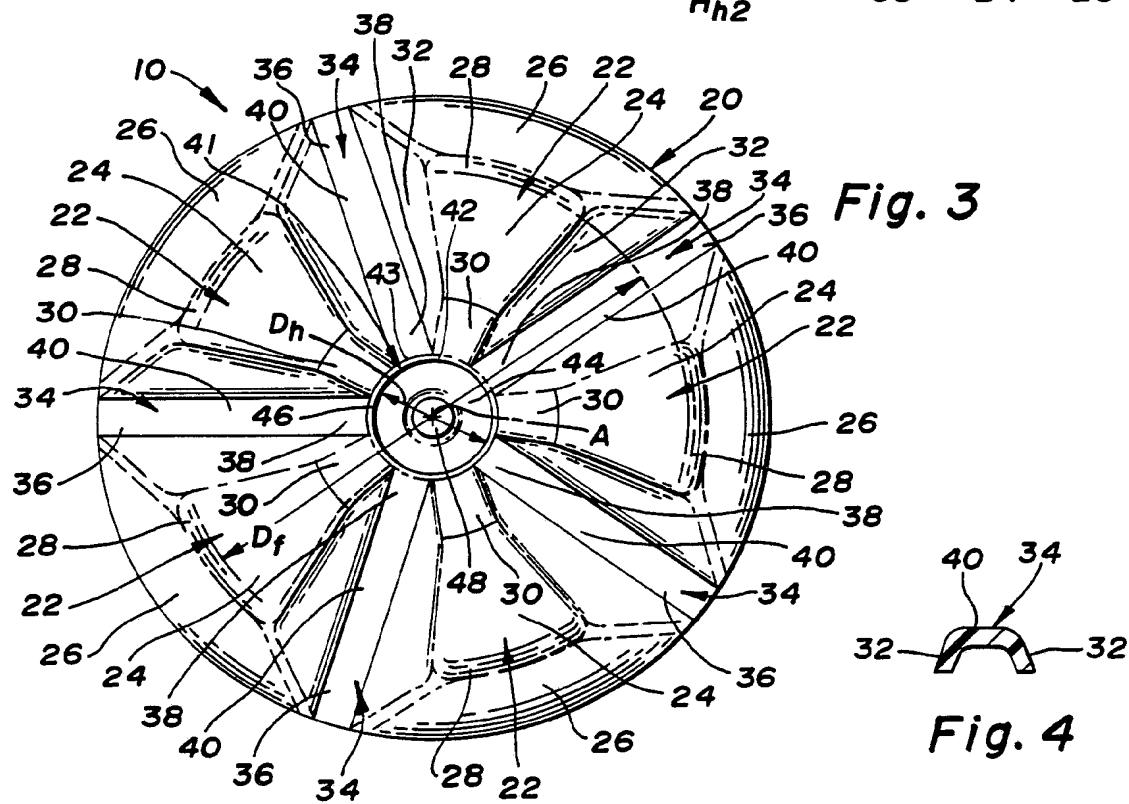


Fig. 4

۲۷۳

Fig. 5

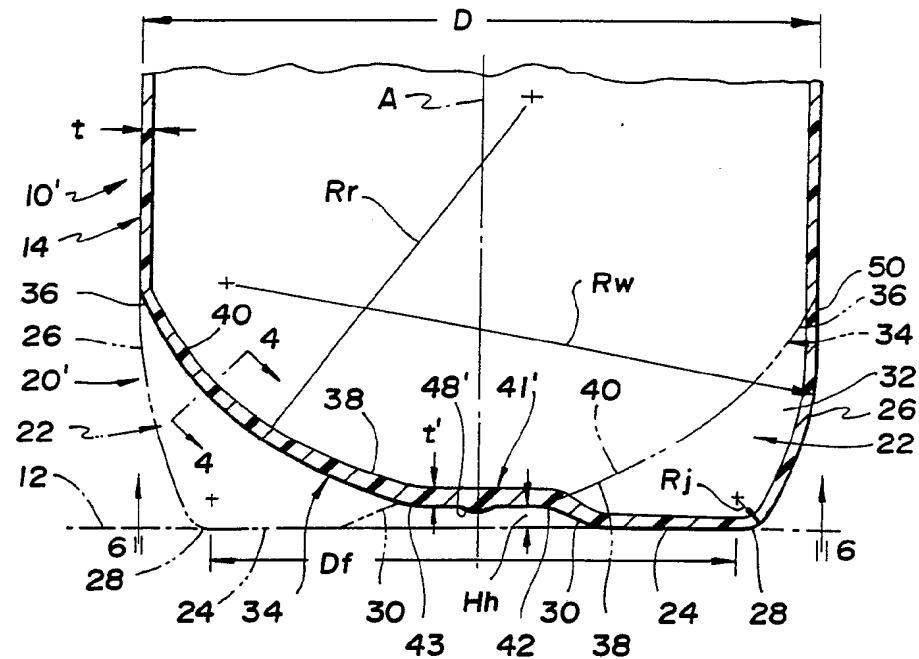


Fig. 6

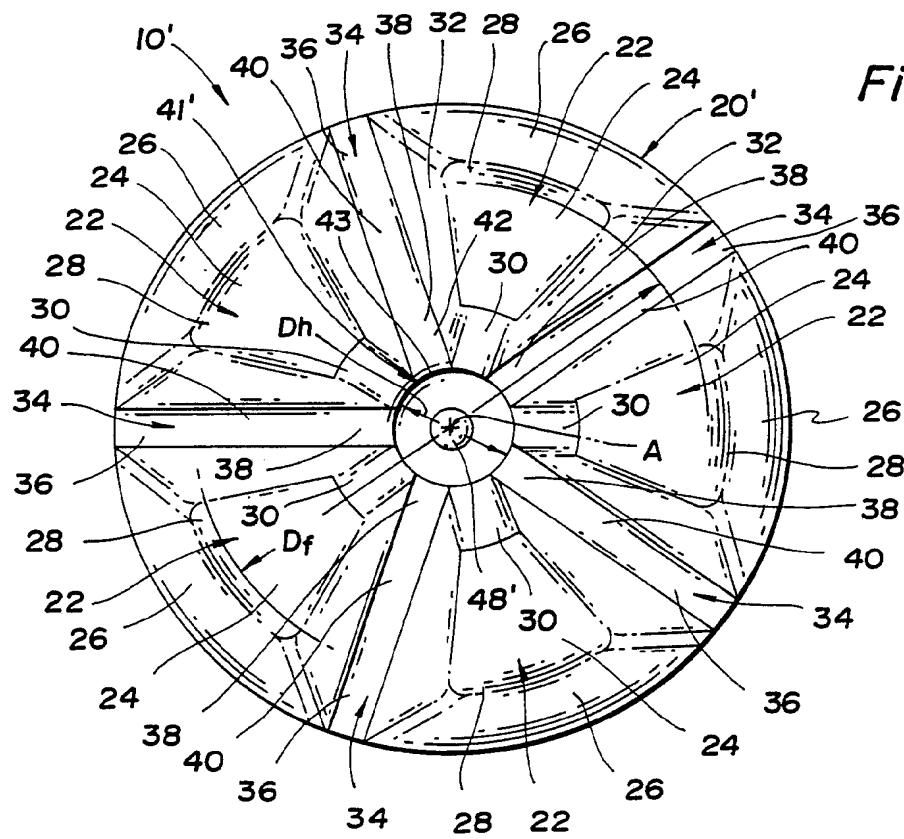


Fig. 7

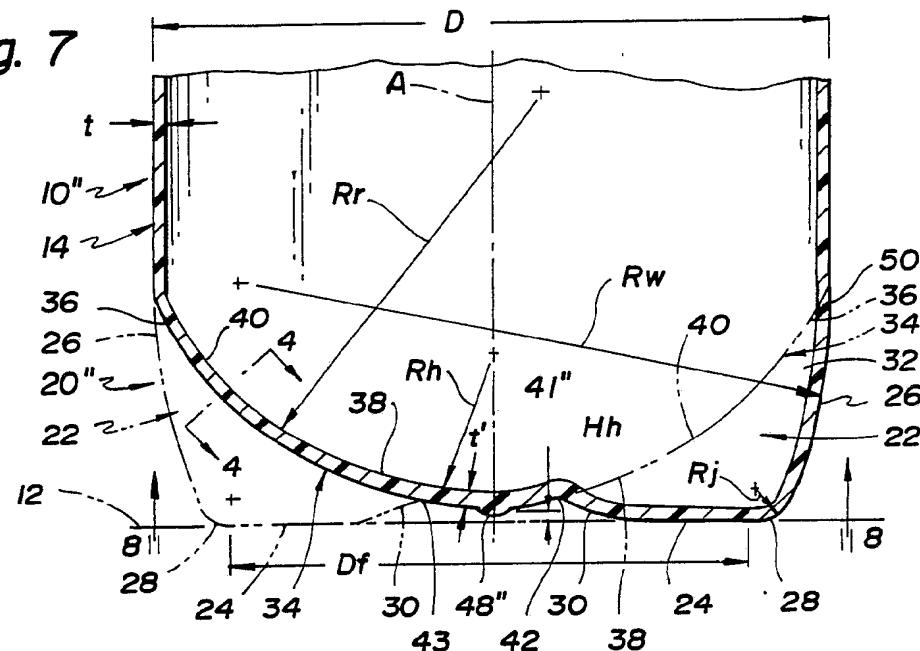
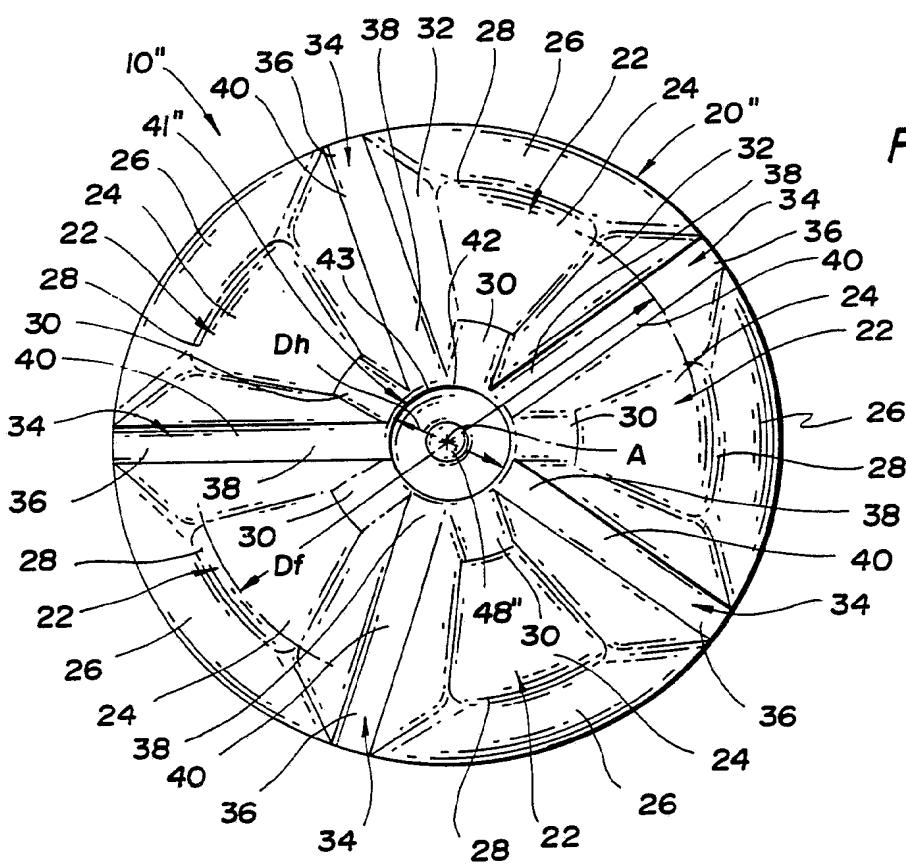


Fig. 8



INTERNATIONAL SEARCH REPORT

International Application No. PCT/US91/07387

I. CLASSIFICATION OF SUBJECT MATTER (if several classification symbols apply, indicate all) *

According to International Patent Classification (IPC) or to both National Classification and IPC

IPC(5) B65D 1/02, 1/00

II. FIELDS SEARCHED

Classification System	Minimum Documentation Searched ?	
		Classification Symbols
US	215/1C, 220/628, 631, 635	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched *		

III. DOCUMENTS CONSIDERED TO BE RELEVANT *

Category *	Citation of Document, ** with indication, where appropriate, of the relevant passages ***	Relevant to Claim No. *
A	US, A, 4,850,493 (HOWARD, JR.) 25 JULY 1989	
A	US, A, 4,785,948 (STRASSHEIMER) 22 NOVEMBER 1988	
A	US, A, 4,785,949 (KRISHNEKUMAR ET. AL.) 22 NOVEMBER 1988	
A	US, A, 4,865,206 (BEHM ET. AL.) 12 SEPTEMBER 1989	
A	US, A, 4,867,303 (POWERS) 19 SEPTEMBER 1989	
A	US, A, 4,889,752 (BECK) 26 DECEMBER 1989	

* Special categories of cited documents: **

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

& document member of the same patent family

IV. CERTIFICATION

Date of the Actual Completion of the International Search

Date of Mailing of this International Search Report

23 JANUARY 1992

12 MAR 1992

International Searching Authority

Signature of Authorized Officer

ISA/US

J. MOY